



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4292-1**Job Sheet 185246****Part No:** D4292-1**Job Qty:** 4 ea**Part Name:** Fitting**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/24/18**Job Tracking No:****Due Date:** 10/12/18**Created By:** Jason Leroux**Type:** SOLD**Description:**

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-2		SBZ 18/10/24
100	Bandsaw	4 pcs	10/12/18	10/12/18	0.00	0.34	Bandsaw1		SBZ 18/10/24
110	CNC Vertical Machining	4 pcs	10/12/18	10/12/18	0.51	8.23	HAAS 5 Axis		18/10/25
120	QC	4 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-2		18/10/25
130	QC	4 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-2		18/10/25
140	HandFinish	4 pcs	10/12/18	10/12/18	0.00	0.22	HandFinish1		18/10/26
145	Powdercoat	4 pcs	10/12/18	10/12/18	0.00	0.30	Powdercoat1		18-10-26
150	QC	4 pcs	10/12/18	10/12/18	0.00	0.00	QC3		18/10/26
151	Small Fab	4 pcs	10/12/18	10/12/18	0.00	0.18	Small Fab-6		18/10/26
152	QC	4 pcs	10/12/18	10/12/18	0.00	0.00	QC5		18/10/26
180	Packaging	4 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2		18/10/26
190	QC21-SA	4 Ea	10/12/18	10/12/18	0.00	0.00	QC21		18/10/26

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00*****

Descriptions: 110 - 1-Machine per folio FB002

145 - MASK THREADED HOLE

151 - INSTAL HELICOIL

M 138951 START: 8:05 O.V.T. 320° FINISH: 8:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4"	2.0800 ft (.52 ea)	90-Start up Operation	5043340
MS21209F1-10	Heli Coil	4 Ea (1 ea)	151-Small Fab	5044218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	2	24	0
151-Small Fab	MS21209F1-10	4	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk
2	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	
3	Fitting	0.125Inches + 0.030 - 0.010	0.155 0.115	
4	Fitting	2.950Inches ± 0.030	2.980 2.920	
5	Fitting	0.275Inches ± 0.010	0.285 0.265	
6	Fitting	0.800Inches ± 0.010	0.810 0.790	
7	Fitting	0.825Inches ± 0.010	0.835 0.815	
8	Fitting	0.375Inches ± 0.010	0.385 0.365	
9	Fitting	0.310Inches ± 0.030	0.340 0.280	
10	Fitting	0.880Inches ± 0.030	0.910 0.850	
11	 DART AEROSPACE Container No: S121176  Part: D4292 - 1 Job No: 185246 Serial No/Batch: S121176 Revision: Inspector: Exp Date: Instructions: Various STC's Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 10/24/18			
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27	Fitting	0.250Inches ± 0.030	0.280 0.220	Radius
28	Fitting	0.060Inches ± 0.030	0.090 0.030	Radius
29	Fitting	4.875Inches ± 0.010	4.885 4.865	
30	Fitting	0.493Inches ± 0.010	0.503 0.483	
31	Fitting	0.765Inches ± 0.010	0.775 0.755	c-bore
32	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	
33	Fitting	0.680Inches ± 0.010	0.690	

			0.670	
34	Fitting	2.250Inches ± 0.010	2.260 2.240	
35	Fitting	4.500Inches ± 0.010	4.510 4.490	
36	Fitting	1.275Inches ± 0.010	1.285 1.265	
37	Fitting	0.031Inches ± 0.010	0.041 0.021	Radius
38	Fitting	0.130Inches ± 0.030	0.160 0.100	Radius
39	Fitting	1.650Inches ± 0.030	1.680 1.620	
40	Fitting	1.421Inches ± 0.010	1.431 1.411	

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DART AEROSPACE LTD		Work Order: 185246
Description: Fitting		Part Number: D4292-1
Inspection Dwg: D4292	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.063	✓		RG	
0.250	+0.030/-0.010	.255	✓		Vern	Sub-01
0.125	+0.030/-0.010	.130	✓		"	
2.95	+/-0.030	2.951	✓			
0.275	+/-0.010	.280	✓		"	
0.800	+/-0.010	.800	✓			
0.825	+/-0.010	.823	✓		✓	
0.375	+/-0.010	.376	✓			
0.31	+/-0.030	.310	✓			
0.88	+/-0.030	.882	✓			
0.663	+/-0.010	.661				
Ø0.381	+0.000/-0.001	.380				
1.125	+/-0.010	1.125				
1.063	+/-0.010	1.062				
3.44	+/-0.030	3.438	✓		Vern	Sub-01
2.450	+/-0.010	2.448	✓			
1.325	+/-0.010	1.327	✓			
0.300	+/-0.010	.301	✓			
1.200	+/-0.010	1.202	✓			
2.84	+/-0.030	2.840	✓			
0.19	+/-0.030	.188	✓			
5.86	+/-0.030	5.864	✓			
5.99	+/-0.030	5.995	✓			
Ø0.272	+0.006/-0.001	.272	✓			
Ø0.266	+0.006/-0.001	.266	✓			
1.75	+/-0.030	1.753	✓			
R0.25	+/-0.030	.250	✓		RG	
R0.06	+/-0.030	.06	✓		RG	
4.875	+/-0.010	4.874	✓		Vern	Sub-01
0.493	+/-0.010	.493	✓			
C-bore Ø0.765	+/-0.010	.765	✓		P.G.	
0.250	+0.030/-0.010	.253	✓			
0.680	+/-0.010	.680	✓			
2.250	+/-0.010	2.250	✓			
4.500	+/-0.010	4.500	✓			
R1.275	+/-0.010	1.275	✓			
R0.031	+/-0.010	.031	✓		RG	

DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4292-1
Inspection Dwg: D4292 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	1.30	✓		R.G.	
1.65	+/-0.030	1.656	✓		H.C.	
1.421	+/-0.010	1.422	✓		Vern	

Measured by: DAS 57	Audited by: mmc	Preliminary Approval:
Date: 9-89 18/10/24	Date: 18/10/25	Date:

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	AA